

# Work Order ID 52257

September 22, 2009 7:03:40 AM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID: H

Stop



Item Name: Replacement Float Skidtube

Start Date: 9/22/09 Start Qty: 1.00



Cust Item ID:

Required Date: 9/25/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

If D412-742-043 is a W/O on it's own,  
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A

# Work Order ID 52257

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Item ID: D412-742-043  
Revision ID: H  
Item Name: Replacement Float Skidtube

Accept



Setup Start



Stop



Start Date: 9/22/09 Start Qty: 1.00  
Required Date: 9/25/09 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

\*\*\*\*\*Do not apply LPS, see QC for more info\*\*\*\*\*

X 1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391  
A/R LPS-3 MIA

2-Install tubes together and seal them all the way around using Sikaflex  
241/291. Ensure tube ends line-up with saddle holes for proper alignment. using  
7/16" "T" Pins.  
A/R Sikaflex-241/-291 M112391  
Expiry date: 10/20

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against  
wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".  
Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten  
only bolts with no sikaflex.  
A/R LPS Procyon M1104251  
A/R Sikaflex-241/-291 M112391  
Expiry date: 10/20

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with  
MEK degreaser.

91 09/09/22 (X1) 0

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Item ID: D412-742-043  
Revision ID: H  
Item Name: Replacement Float Skidtube

Accept



Setup Start  
Stop



Start Date: 9/22/09 Start Qty: 1.00  
Required Date: 9/25/09 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

7 8 02/04/22

(+1)

φ

130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-742-043

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

0.00

0.00

PP 52424 9/1/28 @ SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/30 HJ

CX 09/09/30

# Picklist Print

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Page 1

8

Work Order ID: 52257

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Start Date: 9/22/09

Required Date: 9/25/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN3C4A                          |                        | Purchased     | No          |                     |                  | 110             | Each               | 2,100.000      | 24.0000                  |               |                |        |



BOLT



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |

Main Warehouse

|        |      |  |
|--------|------|--|
| ST     | 2100 |  |
| 112082 | 14   |  |
| 112314 | 140  |  |
| 112612 | 246  |  |
| 112720 | 1200 |  |
| 112724 | 500  |  |

x 24 22 09/09/22

AN3C6A

Purchased

No

110 Each

1,012.000 12.0000



BOLT



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |

Main Warehouse

|        |      |  |
|--------|------|--|
| ST     | 1012 |  |
| 110372 | 52   |  |
| 111982 | 960  |  |

x 12 22 09/09/22

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 52257

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube



Start Date: 9/22/09

Required Date: 9/25/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name                                                   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick                                                            | Qty<br>Issued | Date<br>Issued | Status |
|-----------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------------------------------------------------------------------------------|---------------|----------------|--------|
| AN3C7A                                                                            |                        | Purchased     | No          |                     |                  | 110             | Each               | 297.0000       | 8.0000                                                                              |               |                |        |
|  |                        |               |             |                     |                  |                 |                    |                |  |               |                |        |
| BOLT                                                                              |                        |               |             |                     |                  |                 |                    |                |                                                                                     |               |                |        |



Warehouse      Loc Qty      Loc Code  
Location

Main Warehouse

ST      297

105906      21

107376      276

|                                                                                   |  |           |    |  |  |     |      |           |                                                                                     |  |  |  |
|-----------------------------------------------------------------------------------|--|-----------|----|--|--|-----|------|-----------|-------------------------------------------------------------------------------------|--|--|--|
| AN960C10L                                                                         |  | Purchased | No |  |  | 110 | Each | 6,964.000 | 44.0000                                                                             |  |  |  |
|  |  |           |    |  |  |     |      |           |  |  |  |  |
| washer                                                                            |  |           |    |  |  |     |      |           |                                                                                     |  |  |  |

18 41 09/09/02

Warehouse      Loc Qty      Loc Code  
Location

OFFSHORE

FG      100



103585      100

Main Warehouse

ST      6864

112116      1864

112612      5000

|                                                                                     |  |              |    |  |  |     |      |        |                                                                                       |  |  |  |
|-------------------------------------------------------------------------------------|--|--------------|----|--|--|-----|------|--------|---------------------------------------------------------------------------------------|--|--|--|
| D3391-021RevH                                                                       |  | Manufactured | No |  |  | 110 | Each | 0.0000 | 1.0000                                                                                |  |  |  |
|  |  |              |    |  |  |     |      |        |  |  |  |  |
| Fwd Tube Assembly                                                                   |  |              |    |  |  |     |      |        |                                                                                       |  |  |  |

already pulled 1346980  
in 48084 03291-023

18 41 09/09/22 41

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Shop Packet Print

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 52257

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Comments:

Start Date: 9/22/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D3391-023RevH

Manufactured

No

110

Each

1.0000

1.0000



Mid Tube Assembly

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

1348084

x1

41 09/09/22

ST

1

40522

1

D3391-025RevH

Manufactured

No

110

Each

2.0000

1.0000



Aft Tube Assembly

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

1350104

x1

41 09/09/22

ST

2

39129

1

48122

1



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Work Order ID: 52257

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Comments:

Start Date: 9/22/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3564-1 RevD                    |                        | Manufactured  | No          |                     |                  | 110             | Each               | 29.0000        | 1.0000                   |               |                |        |



Wearshoe

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| OFFSHORE         |                |                 |
| FG               | 2              |                 |
| 33798            | 2              |                 |
| Main Warehouse   |                |                 |
| ST               | 27             |                 |
| 47531            | 1              |                 |
| 48163            | 5              |                 |
| 51676            | 21             |                 |

B-163

X1 Jlf 09/09/22

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 52257

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Comments:

Start Date: 9/22/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3564-3RevD                     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 23.0000        | 1.0000                   |               |                |        |



Wearshoe



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| OFFSHORE         |                |                 |
| FG               | 2              |                 |
| 33764            | 2              |                 |
| Main Warehouse   |                |                 |
| FP               | 11             |                 |
| 50113            | 11             |                 |
| Main Warehouse   |                |                 |
| ST               | 10             |                 |
| 46445            | 1              |                 |
| 46652            | 6              |                 |
| 50364            | 3              |                 |

81 48 09/09/22

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Work Order ID: 52257

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Comments:

Start Date: 9/22/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3564-5RevD                     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 47.0000        | 1.0000                   |               |                |        |



Wearshoe



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| OFFSHORE         |                |                 |
| FG               | 2              |                 |
| 34806            | 2              |                 |
| Main Warehouse   |                |                 |
| FP19             | 43             |                 |
| 51257            | 2              |                 |
| 51655            | 41             |                 |
| Main Warehouse   |                |                 |
| ST               | 2              |                 |
| 45824            | 1              |                 |
| 47433            | 1              |                 |

x1 09/09/22

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 52257

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Comments:

Start Date: 9/22/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3566-1RevC                     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 49.0000        | 2.0000                   |               |                |        |



Gasket



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 39

51612 23

51912 16

Main Warehouse

ST 10

46349 1

47434 2

51218 1

51259 6

x2 41 09/04/27

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

September 22, 2009 7:03:29 AM

Page 8

Work Order ID: 52257

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Start Date: 9/22/09

Required Date: 9/25/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3566-5RevC                     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 55.0000        | 1.0000                   |               |                |        |



Gasket



| <u>Warehouse</u><br><u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-------------------------------------|----------------|-----------------|
| Main Warehouse                      |                |                 |
| FP                                  | 12             |                 |
| 51929                               | 12             |                 |
| Main Warehouse                      |                |                 |
| FP19                                | 36             |                 |
| 51669                               | 36             |                 |
| Main Warehouse                      |                |                 |
| ST                                  | 7              |                 |
| 36113                               | 1              |                 |
| 46186                               | 1              |                 |
| 47318                               | 1              |                 |
| 51260                               | 4              |                 |

xl

91 09/04/22

September 22, 2009 7:03:29 AM

Shop Packet Print

Page 8

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

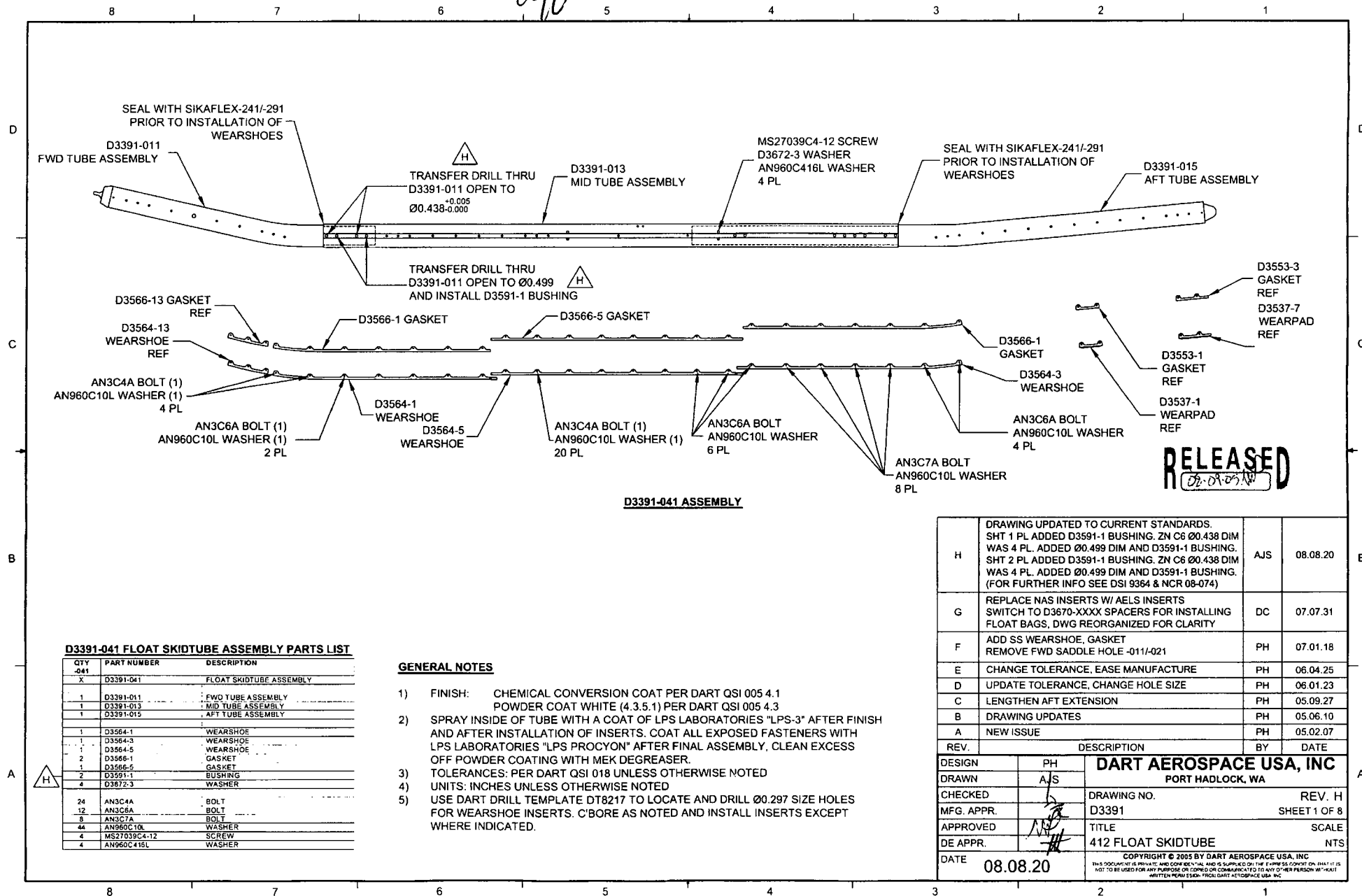
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

u/o 52257



**D3391-041 ASSEMBLY**

**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

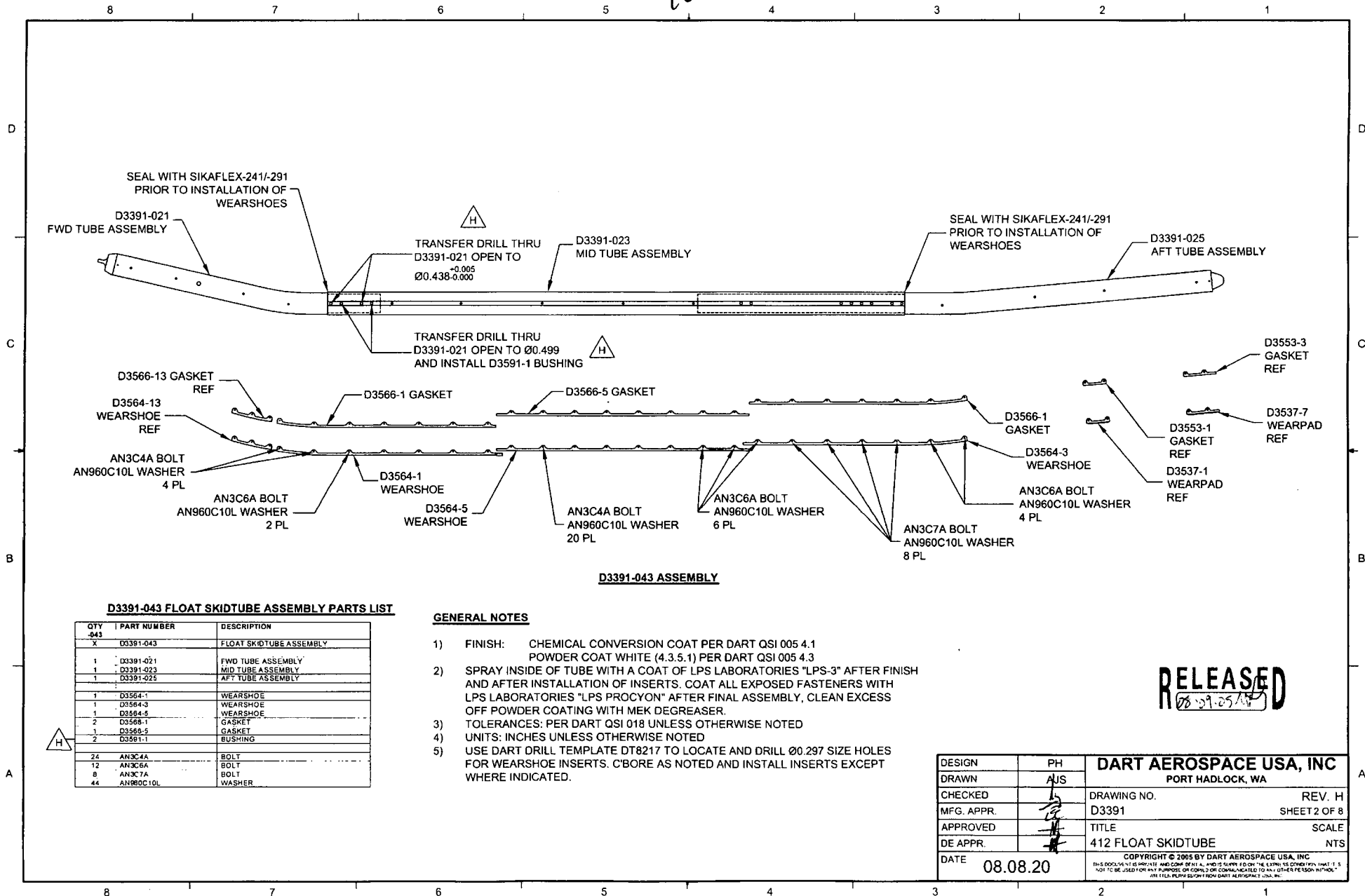
| QTY  | PART NUMBER  | DESCRIPTION                       |
|------|--------------|-----------------------------------|
| -041 | X            | D3391-041 FLOAT SKIDTUBE ASSEMBLY |
| 1    | D3391-011    | FWD TUBE ASSEMBLY                 |
| 1    | D3391-013    | MID TUBE ASSEMBLY                 |
| 1    | D3391-015    | AFT TUBE ASSEMBLY                 |
| 1    | D3564-1      | WEARSHOE                          |
| 1    | D3564-5      | WEARSHOE                          |
| 2    | D3566-1      | GASKET                            |
| 1    | D3566-5      | GASKET                            |
| 2    | D3591-1      | BUSHING                           |
| 4    | D3672-3      | WASHER                            |
| 24   | AN3C4A       | BOLT                              |
| 12   | AN3C6A       | BOLT                              |
| 8    | AN3C7A       | BOLT                              |
| 4A   | AN960C10L    | WASHER                            |
| 4    | MS27039C4-12 | SCREW                             |
| 4    | AN960C416L   | WASHER                            |

**GENERAL NOTES**

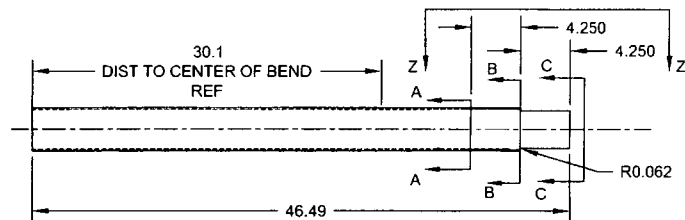
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

|            |                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                      |              |
|------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| H          | DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074) | AJS                                                                                                                                                                                                                                                                  | 08.08.20     |
| G          | REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY                                                                                                                                                              | DC                                                                                                                                                                                                                                                                   | 07.07.31     |
| F          | ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021                                                                                                                                                                                                                             | PH                                                                                                                                                                                                                                                                   | 07.01.18     |
| E          | CHANGE TOLERANCE, EASE MANUFACTURE                                                                                                                                                                                                                                                   | PH                                                                                                                                                                                                                                                                   | 06.04.25     |
| D          | UPDATE TOLERANCE, CHANGE HOLE SIZE                                                                                                                                                                                                                                                   | PH                                                                                                                                                                                                                                                                   | 06.01.23     |
| C          | LENGTHEN AFT EXTENSION                                                                                                                                                                                                                                                               | PH                                                                                                                                                                                                                                                                   | 05.09.27     |
| B          | DRAWING UPDATES                                                                                                                                                                                                                                                                      | PH                                                                                                                                                                                                                                                                   | 05.06.10     |
| A          | NEW ISSUE                                                                                                                                                                                                                                                                            | PH                                                                                                                                                                                                                                                                   | 05.02.07     |
| REV.       | DESCRIPTION                                                                                                                                                                                                                                                                          | BY                                                                                                                                                                                                                                                                   | DATE         |
| DESIGN     | PH                                                                                                                                                                                                                                                                                   | <b>DART AEROSPACE USA, INC</b><br>PORT HADLOCK, WA                                                                                                                                                                                                                   |              |
| DRAWN      | AJS                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                      |              |
| CHECKED    |                                                                                                                                                                                                                                                                                      | DRAWING NO.                                                                                                                                                                                                                                                          | REV. H       |
| MFG. APPR. |                                                                                                                                                                                                                                                                                      | D3391                                                                                                                                                                                                                                                                | SHEET 1 OF 8 |
| APPROVED   |                                                                                                                                                                                                                                                                                      | TITLE                                                                                                                                                                                                                                                                | SCALE        |
| DE APPR.   |                                                                                                                                                                                                                                                                                      | 412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                   | NTS          |
| DATE       | 08.08.20                                                                                                                                                                                                                                                                             | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC<br>THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC |              |

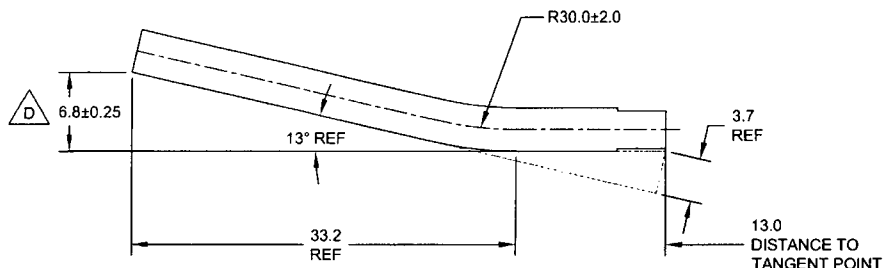
also 52257



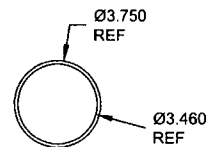
W/O 52257



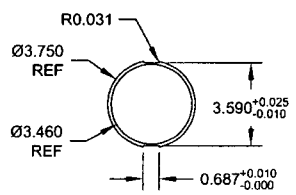
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



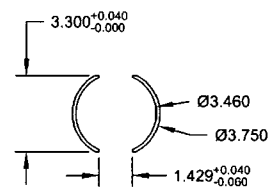
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



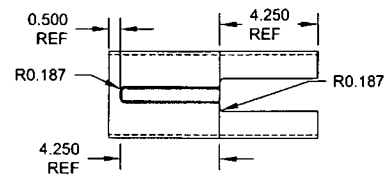
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X

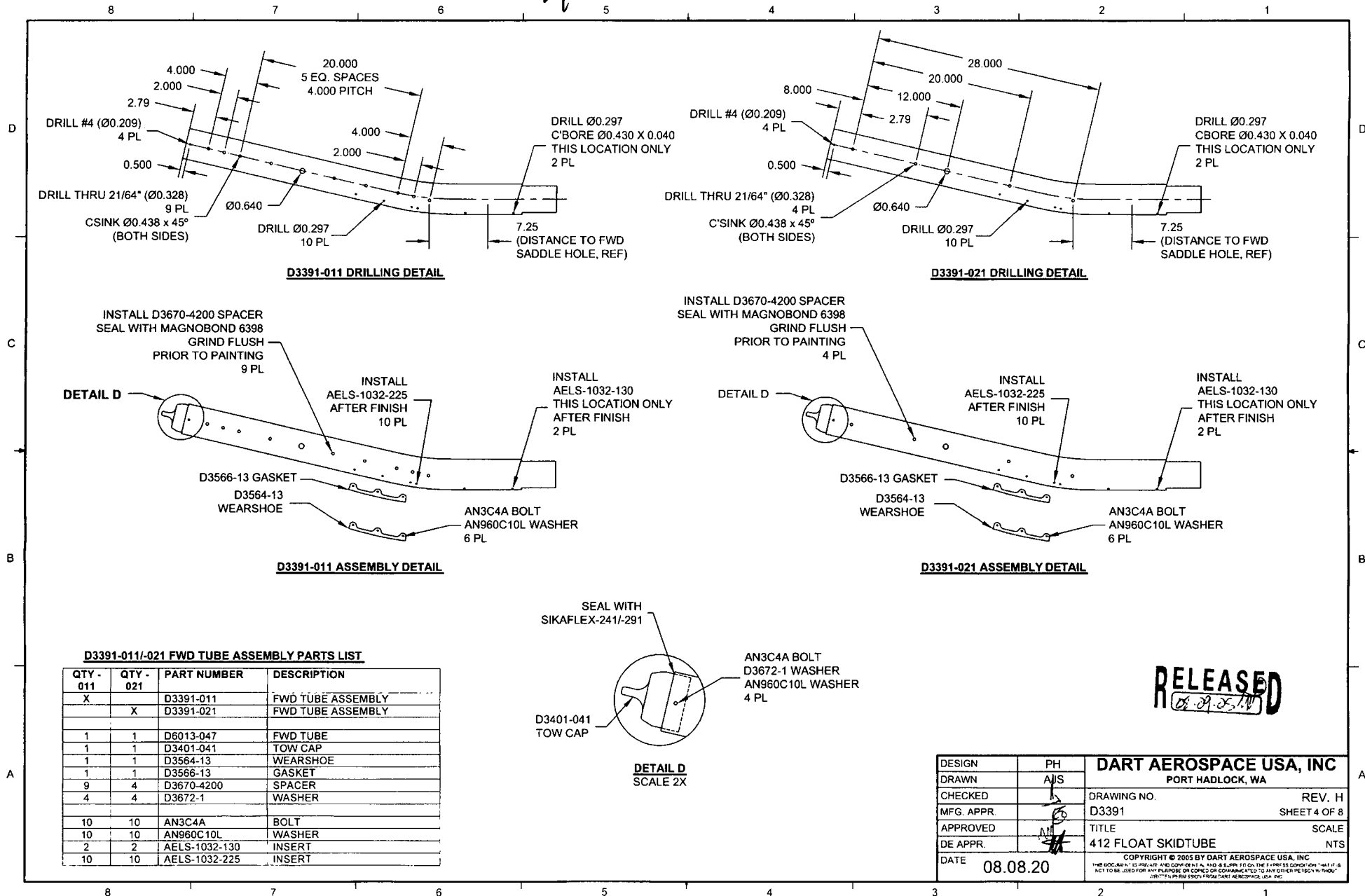


**VIEW Z-Z**  
SCALE 2X

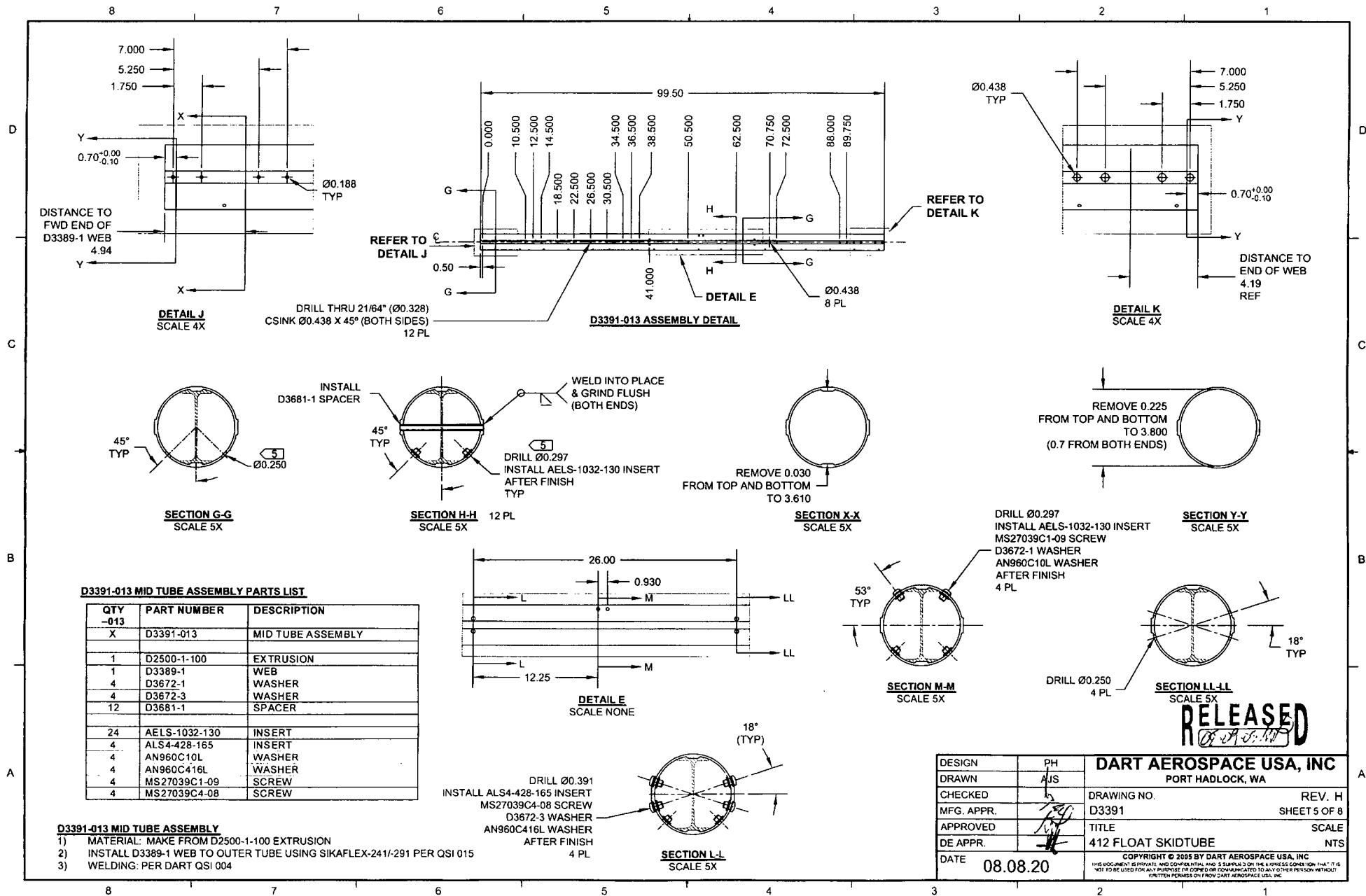
**RELEASED**  
08-05-11

|                                                                                                                                                                                                                                     |          |                                             |              |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|---------------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                              | PH       | <b>DART AEROSPACE USA, INC</b>              |              |
| DRAWN                                                                                                                                                                                                                               | AUS      | PORT HADLOCK, WA                            |              |
| CHECKED                                                                                                                                                                                                                             |          | DRAWING NO.                                 | REV. H       |
| MFG. APPR.                                                                                                                                                                                                                          |          | D3391                                       | SHEET 3 OF 8 |
| APPROVED                                                                                                                                                                                                                            |          | TITLE                                       | SCALE        |
| DE APPR.                                                                                                                                                                                                                            |          | 412 FLOAT SKIDTUBE                          | NTS          |
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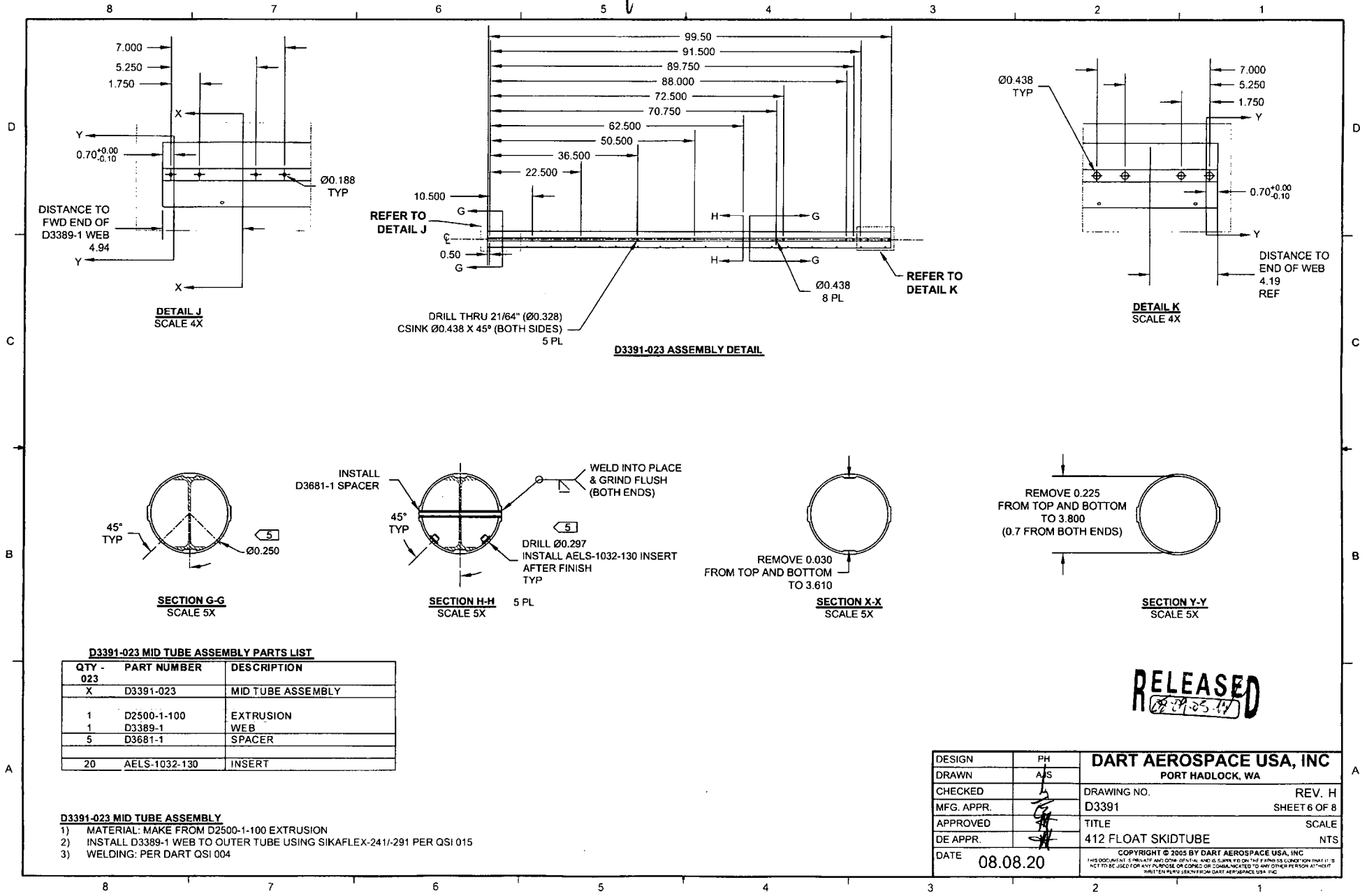


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D3391-023 ASSEMBLY DETAIL

DETAIL J  
SCALE 4X

DETAIL K  
SCALE 4X

SECTION G-G  
SCALE 5X

SECTION H-H  
SCALE 5X

SECTION X-X  
SCALE 5X

SECTION Y-Y  
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

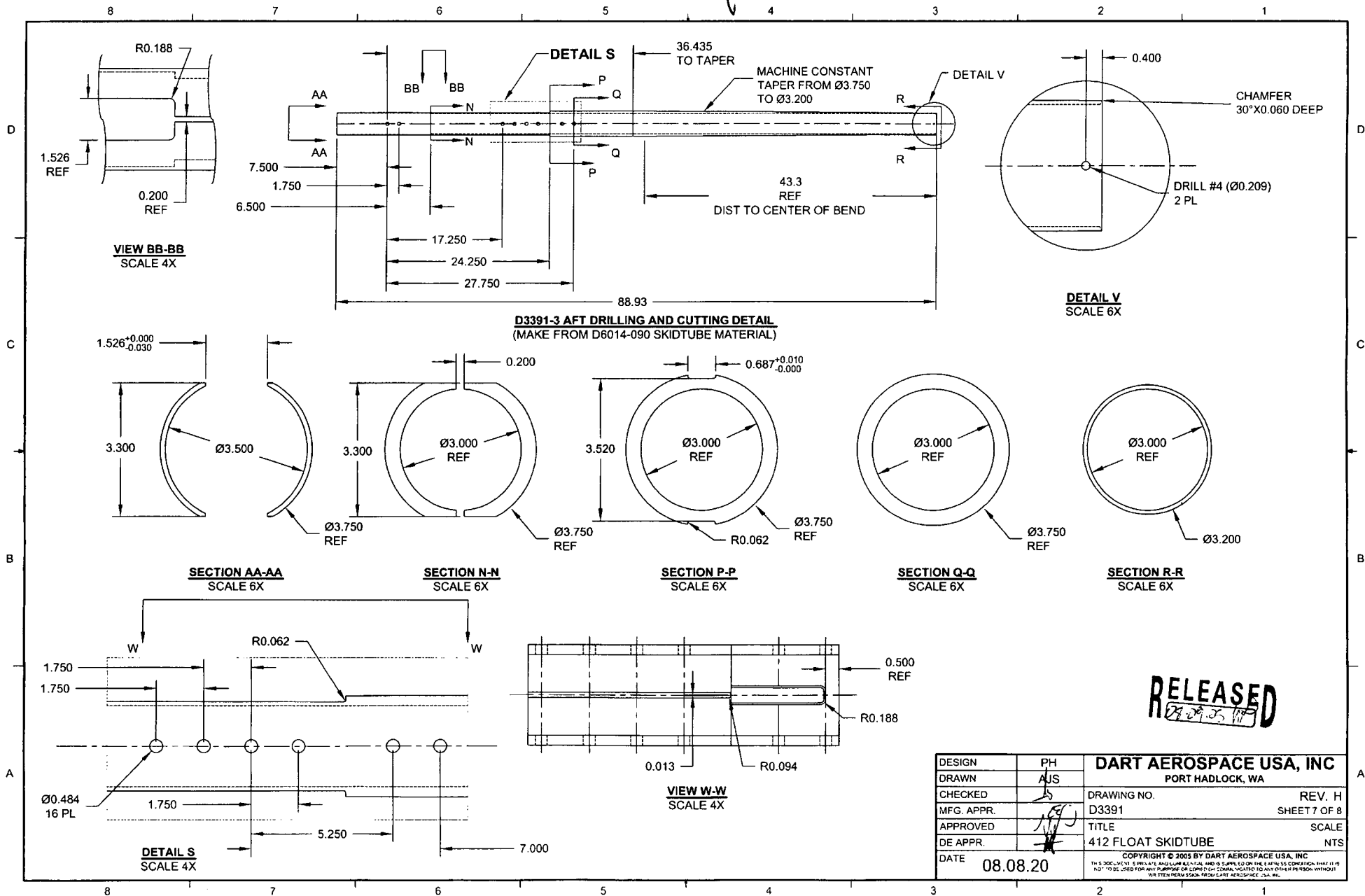
| QTY - | PART NUMBER   | DESCRIPTION       |
|-------|---------------|-------------------|
| 023   |               |                   |
| X     | D3391-023     | MID TUBE ASSEMBLY |
| 1     | D2500-1-100   | EXTRUSION         |
| 1     | D3389-1       | WEB               |
| 5     | D3681-1       | SPACER            |
| 20    | AELS-1032-130 | INSERT            |

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
  - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
  - 3) WELDING: PER DART QSI 004

RELEASED  
08-24-05

|            |          |                                                                                                                                                                                                                                                                                 |              |
|------------|----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | PH       | DART AEROSPACE USA, INC                                                                                                                                                                                                                                                         |              |
| DRAWN      | AS       | PORT HADLOCK, WA                                                                                                                                                                                                                                                                |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                     | REV. H       |
| MFG. APPR. |          | D3391                                                                                                                                                                                                                                                                           | SHEET 6 OF 8 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                           | SCALE        |
| DE APPR.   |          | 412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                              | NTS          |
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|            |                    |                                                                                                                                                                                                                                                                                                    |              |
|------------|--------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | PH                 | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                                     |              |
| DRAWN      | AJS                | PORT HADLOCK, WA                                                                                                                                                                                                                                                                                   |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.                                                                                                                                                                                                                                                                                        | REV. H       |
| MFG. APPR. | <i>[Signature]</i> | D3391                                                                                                                                                                                                                                                                                              | SHEET 7 OF 8 |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                              | SCALE        |
| DE APPR.   | <i>[Signature]</i> | 412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                                                 | NTS          |
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